

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014304**Date Inspected:** 19-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girders (OBG)**Summary of Items Observed:**

Quality Assurance inspector (QA) Michael Foerder was at the American Bridge/Flour (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. OBG Field Splice 3E/4E Face C (Inside) Repairs
2. OBG Field Splice 4E/5E Face A (Outside) UT Review
3. OBG Field Splice 5E/6E Face A (Outside)

Field Splice 3E/4E Face C (Inside) Repairs

The QA inspector periodically observed ABF welding personnel Mitch Sittinger performing shielded metal arc welding (SMAW) in order to excavate and remove rejectable indications previously identified by QC utilizing Ultrasonic Testing (UT). QC inspector Tony Sherwood was noted to be present in order to monitor the progress and adherence to the welding procedure specification designated as ABF-WPS-D1.5-1001 Repair. Mr. Sittinger was noted to be performing the excavations in the general area of Y locations designated 5000mm. After the completion of the cleaning and shaping of the excavations the welder proceeded to perform the shielded metal arc welding (SMAW) and the welding parameters were verified to be 145 with the pre heat and interpass temperature noted to be within the established WPS. A portion of these locations were completed later in the shift and appeared to be in general conformance with the contract documents.

Field Splice 4E/5E Face A (Outside)

The QA inspector periodically observed ABF welding personnel Jordan Hazalaar performing excavations and

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repairs at the following approximate Y locations utilizing a grinder and shielded metal arc welding (SMAW): 14, 530mm, 14,800mm and 15,400mm. QC inspector Tom pascaulone was noted to be present in order to monitor the progress, approve the excavation prior to welding and ensure the welding is in the established parameters of welding procedure specification designated as ABF-WPS-D1.5-1001 Repair. In addition, the QC inspector was noted to be performing ultrasonic testing (UT) for the balance of welds designated A1 and A2. A total of 9 areas with various lengths were noted to be marked for repair during the review of the area and shift. A portion of these areas were completed and the items appeared to be progressing in general conformance with the contract documents.

Field Splice 5E/6E Face A (Outside)

The QA inspector periodically observed ABF welding personnel performing grinding and blending of the areas in which temporary attachments were welded to the deck plate for jacking purposes the previous day. The work progressed throughout a portion of the shift, was completed and QC personnel was noted to perform magnetic particle testing and ultrasonic testing in the areas affected. No rejectable indication were noted at the time of review and the QA inspector did not observed any further work at this location for the remainder of the QA inspectors shift. See digital photos in the body of this report for general information.



Summary of Conversations:

As noted above in items observed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Foerder,Mike	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
